

Ship 11 May.

Work Order ID 132810

Friday, May 08, 2015 9:19:10 AM

132810

Page 1

Item ID: D139-799-029 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: AW139 Hinged Fuel Cap
 Start Date: 5/08/15 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 5/11/15 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: 5-7-8 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D139-799	I								
100		0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D139-799-029 CHG003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

MAY 12 2015 3x
DAS
6
9-89

MAY 11 2015 3x
DAS
27
9-89

MAY 12 2015 3x
DAS
6
9-89

MLJ 1505-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 132810

Friday, May 08, 2015 9:19:10 AM

132810

Page 2

Item ID: D139-799-029

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AW139 Hinged Fuel Cap

Start Date: 5/08/15 Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/11/15 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D139-799-029

Location: 019

PPP rev: _____

3
DAS
6
889
MAY 12 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ MAY 13 2015
MLJ MAY 13 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Friday, May 08, 2015 9:19:14 AM

Page 1

Work Order ID: 132810

132810

Parent Item: D139-799-029

D139-799-029

Parent Item Name: AW139 Hinged Fuel Cap

Start Date: 5/08/15

Required Date: 5/11/15

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 12-10-29 JLM VERIFIED BY:DD IPP
REV:B 14.05.26 chg003/ ECN14-567 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D5043-041

Manufactured No

Each 54.0000

3

D5043-041

Fuel Cap Hinge Assembly

DAS
27
9-89

DAS
26
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST144

54

120846

24

120934

30

3

AN525-416R10

Purchased

No

Each 32.0000

6

AN525-416R10

Screw

DAS
27
9-89

DAS
26
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST327

28

m129520

28

ST329

4

m129246

4

2

4

CB200

Purchased

No

Each 28.0000

3

CB200

Acrylic Adhesive, 3.5G

DAS
27
9-89

DAS
26
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

CA2

20

m131897

20

frigo pk

8

130685

8

3

MAY 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

REFERENCE ONLY

Qty -021	Qty -025	Qty -031	Part Number	Description
X			D139-799-021	CARGO COMPARTMENT PROTECTIVE TRIM KIT
	X		D139-799-025	CARGO COMPARTMENT RAINGUTTER KIT
		X	D139-799-031	CARGO COMPARTMENT PROTECTIVE TRIM KIT
2			D4427-1	SCUFF PLATE
	1		D4456-1	FWD RAINGUTTER, LH
	1		D4456-2	FWD RAINGUTTER, RH
	1		D4456-3	AFT RAINGUTTER, LH
	1		D4456-4	AFT RAINGUTTER, RH
	2		D4456-5	CENTER RAINGUTTER
		2	D4735-1	SCUFF PLATE
10		10	MS21075L3	NUTPLATE
10		10	MS27039-1-09	SCREW
10		10	NAS1149C0332R	WASHER (or AN960C10L)

Qty -023	Part Number	Description
X	D139-799-023	ANTI-ROTATION BLOCK KIT
5	D4310-1	BLOCK, ANTI-ROTATION
10	MS24665-155	PIN, COTTER

Qty -029	Part Number	Description
X	D139-799-029	HINGED FUEL CAP KIT
1	D5043-041	FUEL CAP HINGE ASSEMBLY
2	AN525-416R10	SCREW
1	CB-200	3.5g ACRYLIC ADHESIVE